

131101

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

5

5

Reference:

Date:

Run Start *NR1*

Date:

Stop ***NR2***

Draw Nbr	Revision Nbr
D4775	C

110

5 FF APR 13 2015

Packaging

120

6 FF APR 13 2015

A/R PROSEAL BATCH: 131670

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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March-26-15 1:42:00 PM

131 101

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Strut Assembly

Start Date: 3/26/15 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 3/26/15 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

140	Identify as per dwg & Stock Location: <u>87519</u>	0.00
140		
Packaging	Memo	0.00
Packaging		

150	QC21- Final Inspection - Work Order Release	0.00
150		
QC	Memo	0.00
Quality Control		

MF
15-4-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 131101

131101

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
REV:B 13.08.26 PB1 DD VERF:JLM
13.09.26 AS PER REV.B DD VERF:JLM
AS PER REV.C DD VERF:JLM
IPP
IPP REV:C
IPP REV:D 14.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1 *D4775-1* Strut Tube		Manufactured	No			110	Each	30.0000	1	5	** FF	APR 13 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST514		30							
				128521		10							
				129407		20							
D4777-1 *D4777-1* Rod End Bearing		Manufactured	No			110	Each	4.0000	1	5	** FF	APR 13 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST127		4							
				129849		4							
D4776-1 *D4776-1* Basket Strut Clevis		Manufactured	No			110	Each	20.0000	1	5	** FF	APR 13 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST126		20							
				129794		20							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 131101

131101

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 5.00

Required Qty: 5.00

D4776-5

Manufactured No

110 Each 42.0000 4 20

D4776-5

Spacer

FF

APR 13 2015

Location

Loc Qty

Loc Code

ST127

42

130075

25

130605

17

20

AN3-10A

Purchased No

110 Each 124.0000 2 10

AN3-10A

Bolt

FF

APR 13 2015

Location

Loc Qty

Loc Code

GA

54

m131320

54

ST338a

70

11119

2

m130466

68

10

MS21042L3

Purchased No

110 Each 2,223.000 2 10

MS21042L3

Nut

FF

APR 13 2015

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

830

M131317

830

ST305

973

116549

12

126333

230

M128754

2

M131624

729

10

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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FAULT CATEGORY

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Picklist Print

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Page 3

Work Order ID: 131101

131101

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 5.00

Required Qty: 5.00

MS21209-F615

Purchased

No

110

Each

33.0000

1

5

MS21209-F615

Heli-Coil

FF APR 13 2015

Location

Loc Qty

Loc Code

GA

33

m131270

33

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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